

Date: Thursday, 28/05/2009 9:11:59 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 412 WEB
Job Number : 48244	
Estimate Number : 10466	
P.O. Number :	Part Number : D33891
This Issue : 28/05/2009 S.O. No. :	Drawing Number : D3389 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : D
Previous Run : 47303	Material :
Written By :	Due Date : 12/06/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09-05-28</u>	
Comment : Est Rev:A 05.08.31 New issue KJ/JLM Est Rev:B 06-02-08 As per Rev C JLM Est Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC	

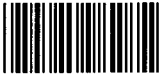
Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D25003100	Ext'n -1' Beam Web 4"
-----	-----------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ext'n -1' Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
1	D2500-3-100	Web Extrusion	B40196

Pm' 09-06-05 (1)

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3389

2-Drill pilot holes using DT8785 as per Dwg D3389

3-Open holes to finish size as per Dwg D3389

4-Deburr

Pm' 09-06-08 (1)

3.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

BE 09-06-08 (1)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm' 09-06-08 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 9:11:59 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 WEB

Job Number: 48244

Part Number: D33891

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D 119-6-8

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

pmc 09-06-08

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/08

Job Completion



mlc
09-06-08

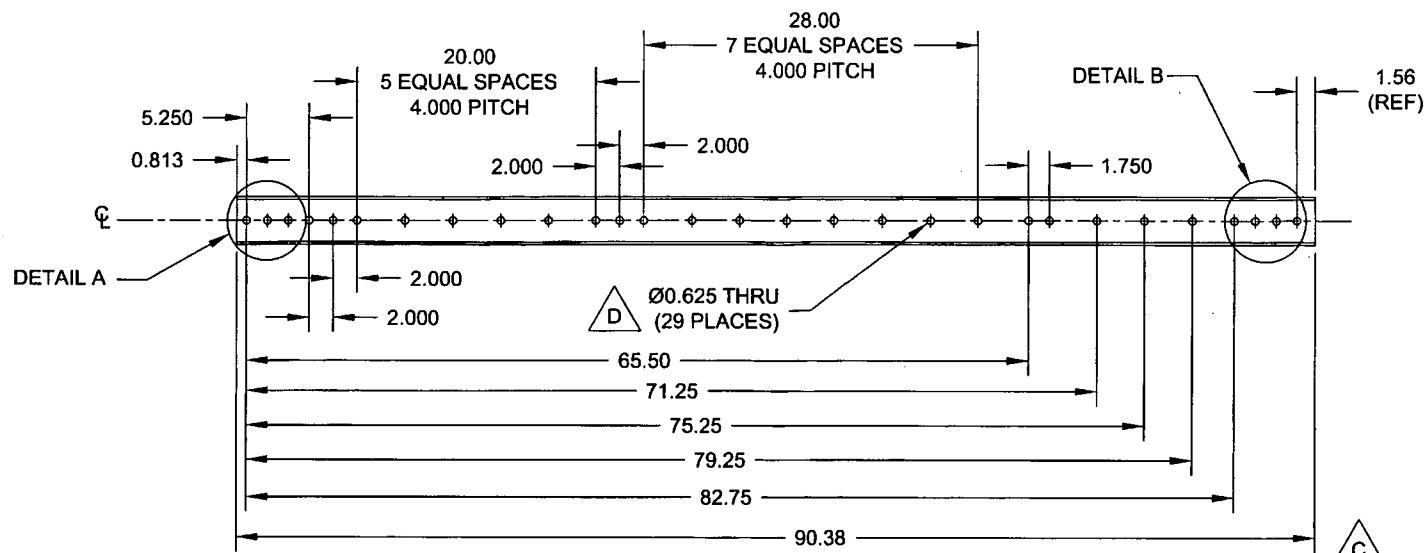
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

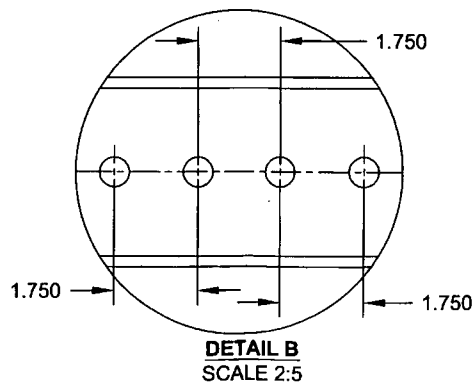
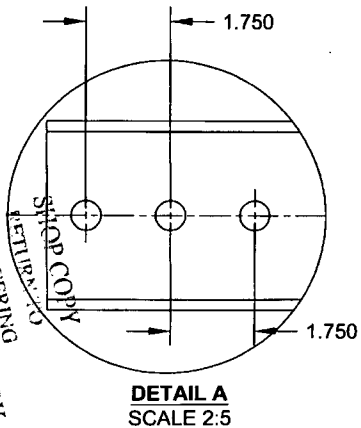
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3389-1 412 WEB



- NOTES:**
- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06

DESIGN	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
DRAWN	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
CHECKED	UPDATE DIMENSIONING	PH	05.06.13
MFG. APPR.	NEW ISSUE	PH	05.02.07
APPROVED			
DE APPR.			
DATE	07.10.09		

DART AEROSPACE USA, INC PORT HADLOCK, WA			
DRAWING NO.	D3389	REV. D	SHEET 1 OF 1
TITLE	412 WEB	SCALE	1:10
COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC			